

Date: Thursday, 13/11/2008 8:20:44 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE		
Job Number	: 43407		Part Number	: D265623		
Estimate Number	: 10615		Drawing Number	: D2656 REV D		
P.O. Number	:		Project Number	: N/A		
This Issue	: 13/11/2008 S.O. No. :		Drawing Revision	: D		
Prsht Rev.	: NC		Material	:		
First Issue	: / / Type : SMALL /MED FAB		Due Date	: 28/11/2008 Qty: 10 Um: Each		
Previous Run	: 41822					
Written By	: <u>JL</u>					
Checked & Approved By	: <u>JL</u>					
Comment	: Est: D 02.10.25 Re-format KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S20GA	1010/1025 SHEET
		 Comment: Qty.: 1.4800 sf(s)/Unit Total : 14.7998 sf(s) 1018 20 GA .040" THK Batch: <u>109289</u> <u>RB 8-11-14</u>
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Dwg D2656 Dwg Rev: <u>D</u> <u>RB 8-11-14</u> Prog Rev: <u>D</u> <u>(B)</u> 2-Deburr if necessary <u>RB 8-11-14</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <u>RB 8-11-14</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		 <u>S 68/11/14 (13)</u>
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		 <u>SB 08/11/21 (13)</u> Comment: NC BRAKE 1-Form on Brake as per Dwg D2656 using Jigs DT8261and DT8326 2-Form joggle as per Dwg D2656 using Jig DT8158 3-Identify as D2656-23 <u>08/11/24 (13)</u>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 13/11/2008 8:20:44 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S.ostulac 413

7.0 POWDER COATING

POWDER COATING



M109648



(13X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

11-30

OVEN TEMPERATURE:

320°

FINISH TIME:

12-00

m/f 08/11/24

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-24 (13)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



(13X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-21

m/f 08/11/24

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/26 M/f

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



M/F 08-11-24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

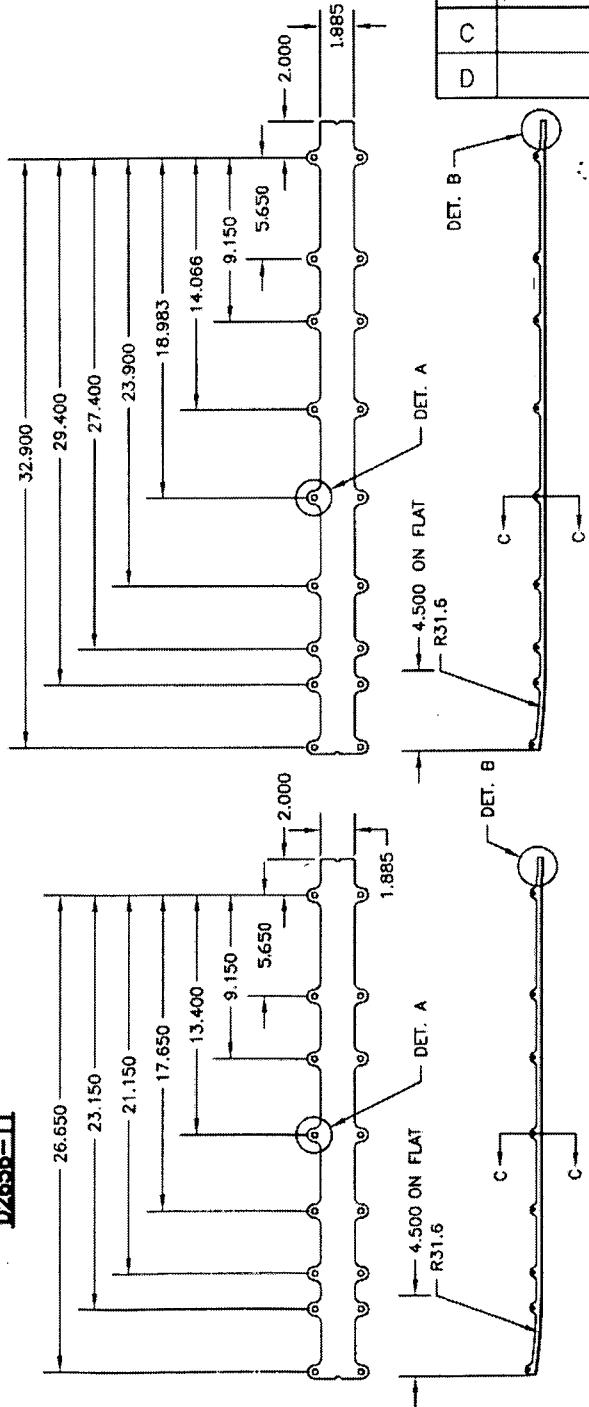
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

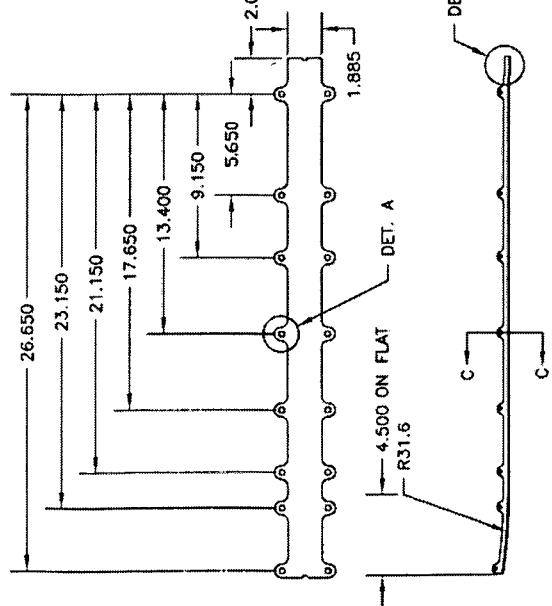


DESIGN	DRAWN BY	DS CP	DART AEROSPACE USA, INC.
CHECKED	APPROVED		PORT HADLOCK, WA
			DRAWING NO. REV. D
			D2656 SHEET 1 OF 4
DATE		TITLE	SCALE
05.08.17		WEARSHOE	1:10

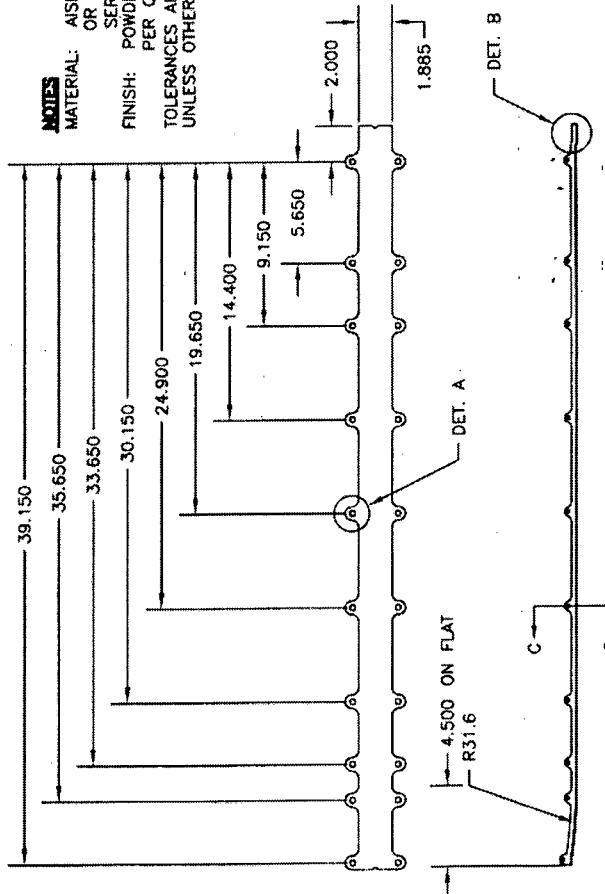
D2656-13



D2656-11



D2656-15



NOTES
 MATERIAL: AISI 1010-1025 OR ASTM A36/A1008
 OR CSA G40-21, 38W/44W/50W/60W/70W
 SERIES STEEL, 20 GAUGE (0.040 THICK)
 FINISH: POWDER COAT GREY SANTEX (4.3)
 PER QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018
 UNLESS OTHERWISE NOTED

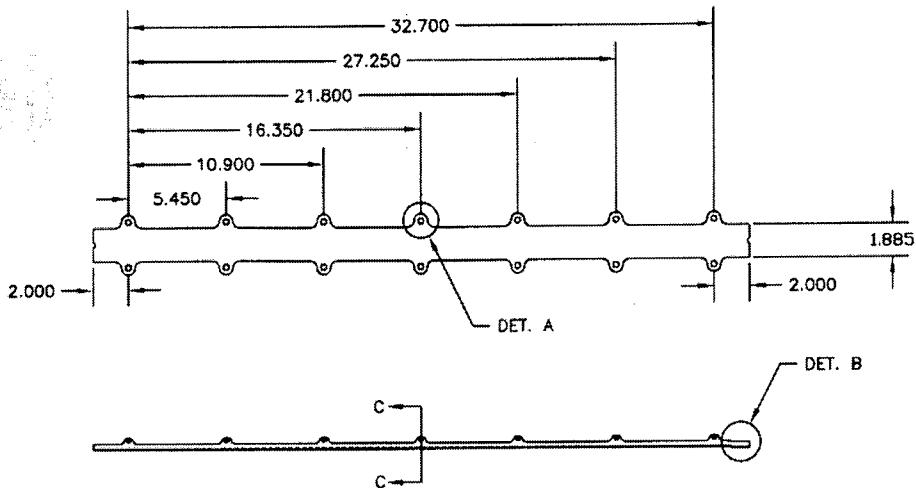
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W043407

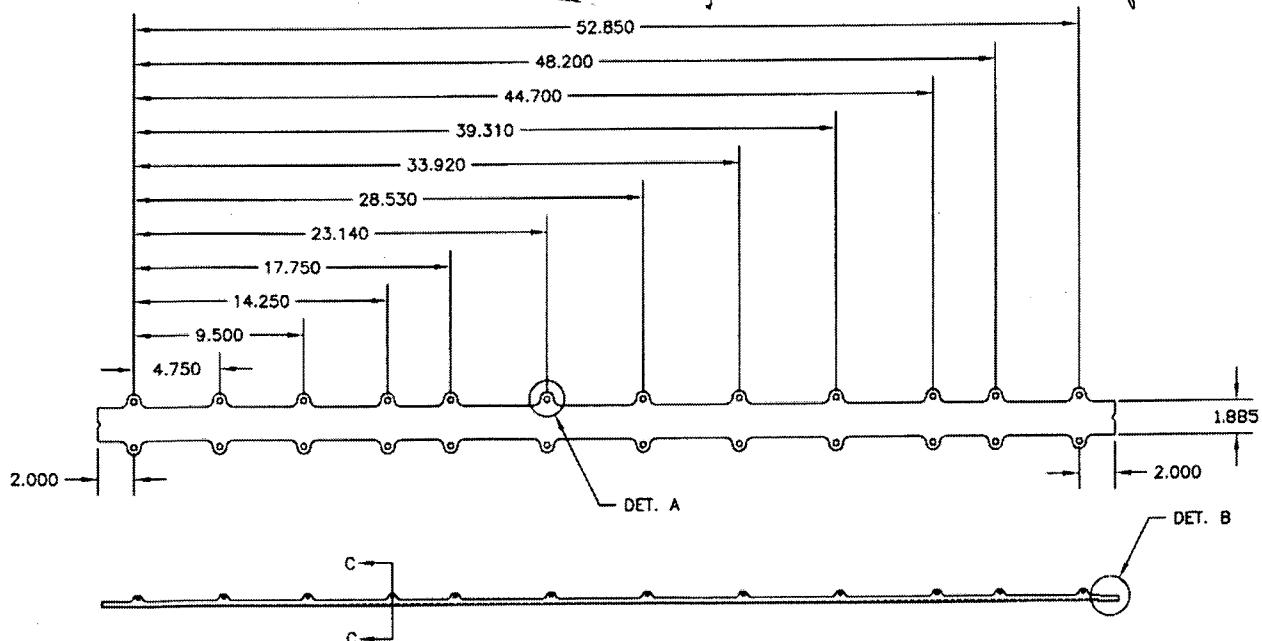


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656
DATE 05.08.17		REV. D SHEET 2 OF 4 TITLE WEARSHOE SCALE 1:10

D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W

SERIES STEEL, 20 GAUZE (0.040 THICK)

FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3

TOLERANCES ARE PER DART QSI 018

UNLESS OTHERWISE NOTED

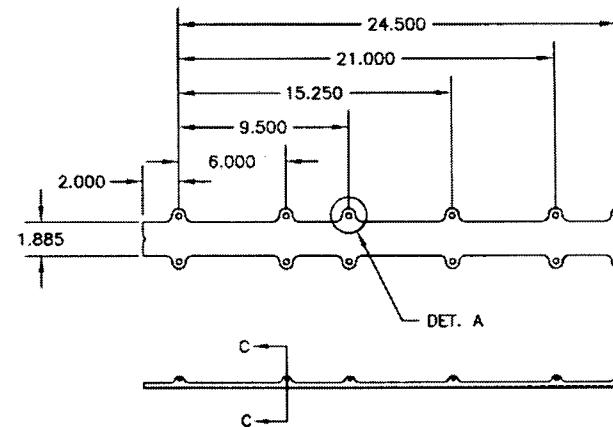
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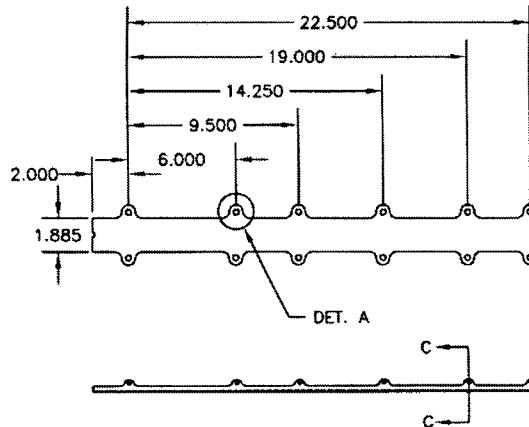


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CHECKED	✓	APPROVED	✓	PORT HADLOCK, WA
DATE	05.07.00	DRAWING NO.	D2656	REV. D
05.08.17	SHEET 3 OF 4	TITLE	WEARSHOE	SCALE 1:10

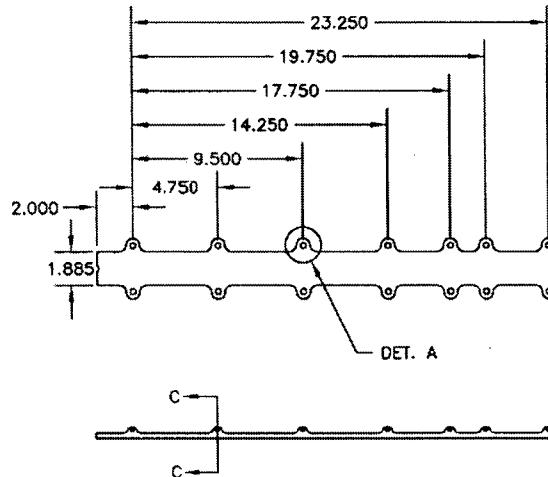
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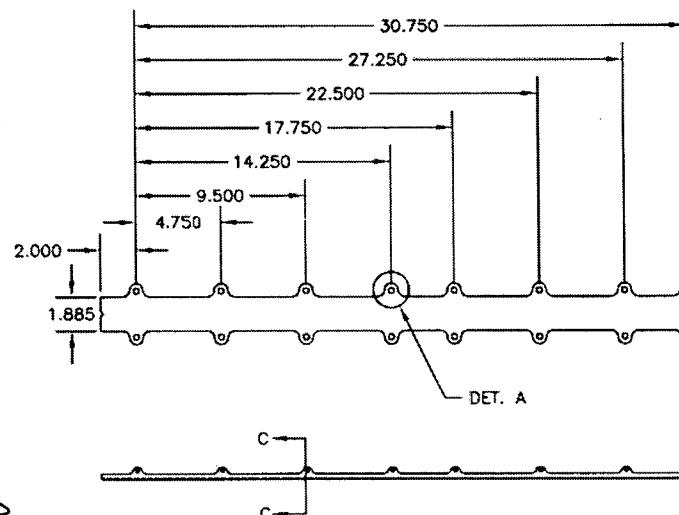
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D2656-35



D2656-37



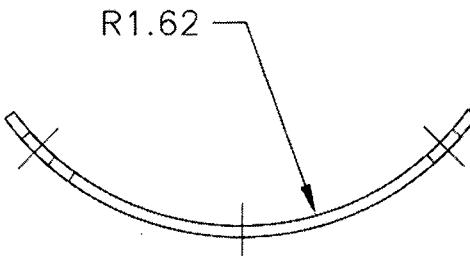
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MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
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TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED



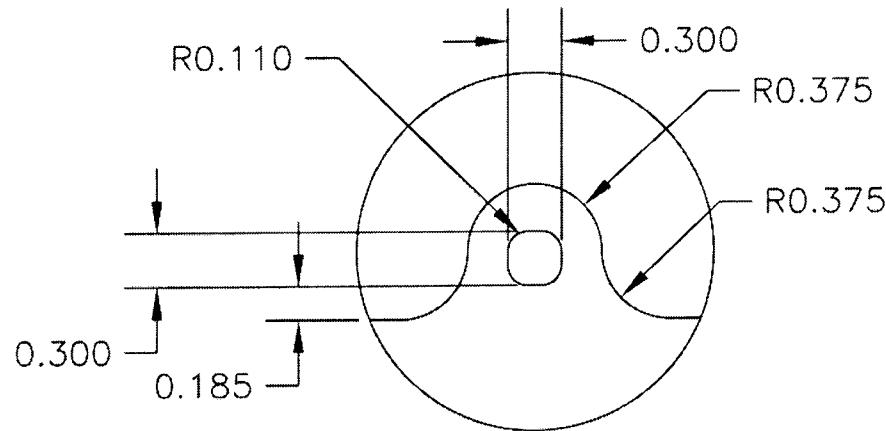
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656	REV. D SHEET 4 OF 4
DATE 05.08.17	TITLE WEARSHOE	SCALE 1:10	

SECTION C-C

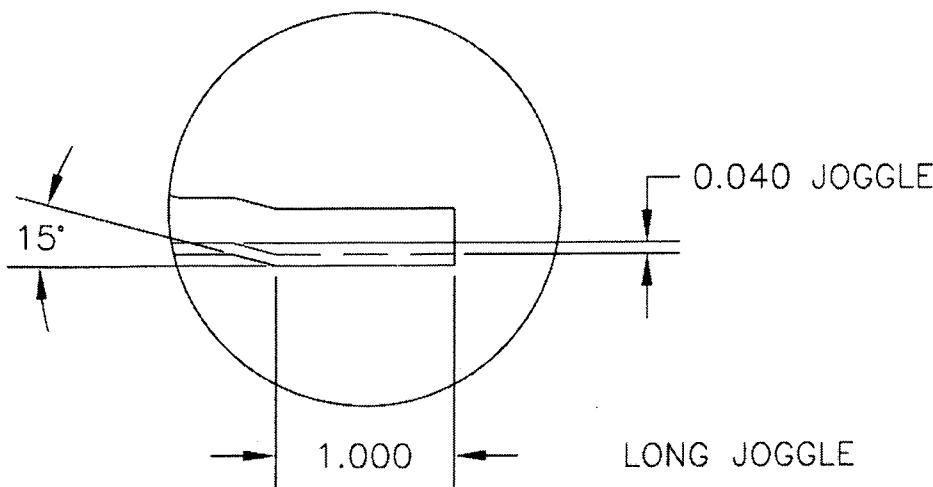


05.09.06-
05.09.06-
05.09.06-
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DETAIL A



DETAIL B



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DART AEROSPACE LTD	Work Order:	43467
Description: WEAR SHOE	Part Number:	D2656-23
Inspection Dwg: D2656-23, Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article x Prototype

Measured by:	BB
Date:	8-11-14

Audited by:	S
Date:	08 July

Prototype Approval:	<i>✓</i>
Date:	<i>7/10/05</i>

Rev	Date	Change	Revised by	Approved
A		New issue	KJ/JLM	